

9

Date: Monday, 2/11/2008 11:38:52 AM  
User: Kim Johnston

# Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SKIDTUBE
Job Number : 37317	
Estimate Number : 11545	
P.O. Number :	Part Number : D204635011
This Issue : 2/11/2008 S.O. No. :	Drawing Number : N/A
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : LANDING GEAR	Drawing Revision : N/A
Previous Run : 29959	Material :
Written By :	Due Date : 2/25/2008 Qty: 1 Um: Each
Checked & Approved By : <u>AS 08 02 11</u>	
Comment : Est Rev:G 02.08.28 Removed QC5 KJ	

## Additional Product

Job Number: 

Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	DC	DOCUMENT CONTROL
-----	----	------------------



KS 08-02-12

Comment: DOCUMENT CONTROL

Photocopy bluefile and Type labels as per PPP D204-635-011CHG005

AS 08/03/20

2.0	37317A	SKIDTUBE
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Comment: Sub-Component Pick:

Qty	Part Number	Description	Batch
1	D204-635-041	Skidtube Assembly	37317A

AS 08/03/20 (X)

3.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

4.0	K10003	D205-634-011 Saddle Kit
-----	--------	-------------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	K10003	Saddle Kit	37536

AS 08/03/20 (X)

5.0	QC4	INSPECT 100% KITS FOR COMPLETENESS
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Comment: INSPECT 100% KITS FOR COMPLETENESS

AS 08/03/20 (X)

37317A

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: A Date: 28/03/04  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action			Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

Date: Monday, 2/11/2008 11:38:52 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKIDTUBE

Job Number: 37317

Part Number: D204635011

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D204-635-011

Location: \_\_\_\_\_

PPP Rev: \_\_\_\_\_

Rev C

SS 08/03/24

④

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/03/24

①

Job Completion



U 08-03-24

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

Date: Monday, 2/11/2008 11:39:20 AM  
 User: Kifn Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SKIDTUBE  
 Job Number : 37317A  
 Estimate Number : 11546  
 P.O. Number :  
 This Issue : 2/11/2008 S.O. No. :  
 Prsht Rev. : NC Part Number : D204635041  
 First Issue : / / Type : LANDING GEAR Drawing Number : D2590 REV D  
 Previous Run : 29959A Project Number : N/A  
 Material : D  
 Due Date : 2/25/2008 Qty: 1 Um: Each  
 Written By :  
 Checked & Approved By :  
 Comment : Est Rev:F 02.08.28 FP was QC5 in Step 27; Added QC5 to Step 30 KJ  
 Est Rev:G 07-07-09 Added SS Wearplates & Gaskets JLM

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D25001190 Ext'n -I' Beam Tube 4"



Comment: Qty.: 1.0400 Each(s)/Unit Total : 1.0400 Each(s)

Pick:

Qty Part Number Description Batch  
 1 D2500-1-190 Skid Tube Extrusion 34729 SL 8-2-13

2.0 D2597 204 Web



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch  
 1 D2597 204 Web 3733 SL 8-2-20

3.0 LANDING GEAR 1 LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

- 1- Inspect mat'l D2500-1-190 for damage
- 2-Cut D2500-1-190 per Dwg D2590 .Deburr ends
- 3-Drill pilot holes using drill jig DT 8149 & DT8711-1&-2
- 4-Acid etch and Alodine tube per QSI 005 4.1
- 5-Open holes to 0.500" as per Dwg D2590 without cutting fluid
- 6-Countersink holes as per Dwg D2590 without cutting fluid
- 7-Deburr and blow out all chips from inside of tube

SL 8-2-19

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Date: Monday, 2/11/2008 11:39:20 AM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKIDTUBE

Job Number: 37317A

Part Number: D204635041

Job Number:



Seq. #:

Machine Or Operation:

Description :

8-Bond web in place per QSI 015. Allow 12 Hrs. cure time before cutting

Pick:

Qty	Part Number	Description	Batch
A/R	Sikaflex-291	105585	
Sikaflex expire date: 8-7-31			
Start Time: 8:20			
Fin Time: 2:00 8-2-27			

SL 8-2-20

4.0

BENDING

BENDING MACHINE



Comment: BENDING MACHINE

Bend as per program D2590.C on CNC Bender

2/SD/DP 8-2-27

5.0

LANDING GEAR 1

LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Cut tubes as per Dwg. D2590.

G.M 08.02.27 O

2-Deburr ends after cutting. Remove alodine from around holes

G.M 08.02.27 O

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

BE 08/03/03

7.0

D25763

Step (Machining Detail)



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2576-3	Step	B33321

BE 08/03/03

8.0

D2579

Crossbolt Spacer



Comment: Qty.: 17.0000 Each(s)/Unit Total: 17.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
17	D2579	Spacers	B36326

BE 08/03/03

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKIDTUBE

Job Number: 37317A

Part Number: D204635041

Job Number:



Seq. #:

Machine Or Operation:

Description:

9.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Prepare tube for welding D2576-3 StepRemove alodine as required.

BE 08/03/03

2-Weld step D2576 as per Dwg. D2590 and QSI 004

A/R

Aluminum Rod

M/106762

BE 08/03/03

3-Weld crossbolt spacers D2579 as per Dwg. D2590 and QSI 004. For D2579 side, pass 3/8" drill, weld other side, pass 3/8" drill

spacers, weld one

A/R

Aluminum Rod

M/106762

BE 08/03/03

4-Grind welds as per Dwg D2590 Grind flush ridge made from bending

5-Drill holes for wearplates using DT 8218 & DT8937 Open holes to 19/64", adjust stopper not to hit web. Deburr

6-Counterbore crossbolt spacers to 7/16" ID x 1.0" deep as per Dwg D2590. Deburr holes

7-Drill pilot holes for aft cap using DT 8215 Open holes to #6 Drill bit. Deburr

8-Drill pilot holes for Tow ring using DT8091, open to .640" and Deburr

28-34

10.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

10 08-03-05 (1)

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

2 08/03/05 (10)

12.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Pressure wash M-1



08/03/05

(1X)

Comment: HAND FINISHING RESOURCE #1

Powder Coat White (Ref: 4.3.5.2) as per QSI 005 4.3

M/107005 M-1 08/03/05

(1K)

13.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL 08/03/06 (1)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKIDTUBE

Job Number: 37317A

Part Number: D204635041

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

D2855

Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Cap

Batch: B35663

BL

15.0

AN35A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Batch: m100188

BL

16.0

AN960JD10L

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

Batch: m104885

BL

\* 17.0

ALS71032130

Insert



Comment: Qty.: 44.0000 Each(s)/Unit Total : 44.0000 Each(s)

Insert

Batch: m105730

BL

18.0

AN3C4A

BOLT



Comment: Qty.: 44.0000 Each(s)/Unit Total : 44.0000 Each(s)

BOLT

Batch: m107008

BL

19.0

AN960C10L

washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

WASHER

Batch: m107008

BL

20.0

D356613

GASKET



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

Batch: B32744

BL

BL 08-03-11

Q

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
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Drawing Name: SKIDTUBE

Job Number: 37317A

Part Number: D204635041

Job Number:



Seq. #:

Machine Or Operation:

Description :

21.0

D35667

GASKET



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

Batch: B37354

22.0

D35661

GASKET



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

GASKET

Batch: B37410

23.0

D356413

WEARSHOE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARSHOE

Batch: B37239

24.0

D356411

WEARSHOE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARSHOE

Batch: B37213

25.0

D35649

WEARSHOE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARSHOE

Batch: B37238

26.0

D35647

WEARSHOE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARSHOE

Batch: B33803

27.0

D25943

O-Ring



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

O-Ring

Batch: B29908

BK 08-03-11

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: D Date: 02/03/24

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 2/11/2008 11:39:20 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SKIDTUBE

Job Number: 37317A

Part Number: D204635041

Job Number:



Seq. #:

Machine Or Operation:

Description :

28.0

D25941

Plug



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)

Plug

Batch: 036327

*BR*

29.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Install inserts & wearplates & gaskets using a drop of Sikaflex on insert holes before installing wearplates

A/R Sikaflex-291

M/05585

Sikaflex expire date: 08-07

2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as per Dwg D2580

3-Inspect for foreign object per QSI 024

4-Install 2855 Aft Cap as per Dwg D2590 and seal Fwd Step & Aft Cap with Sikaflex. Clean excess adhesive

A/R Sikaflex-291

M/05585

Sikaflex expire date: 08-07

*BR. 08-03-11*

5-Wing Walk as per Dwg D2590 and QSI 005 4.4

M/06894

08-03-06

Batch:

M/06894

30.0

QC5

INSPECT WORK TO CURRENT STEP



*08/03/11*



Comment: Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024

31.0

QC21

FINAL INSPECTION/W/O RELEASE



*(1)*

Comment: FINAL INSPECTION/W/O RELEASE

*08/03/04*

Job Completion



*08-03-24*

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries





DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2590	REV. D SHEET 1 OF 2
DATE 07.04.05		TITLE 204 SKIDTUBE ASSEMBLY	SCALE NTS
A	96.09.16	NEW ISSUE	
B	96.12.02	AS MANUFACTURED	
C	98.08.28	REDRAWN, INCLUDED DEO 9094/9097	
D	07.04.05	CHANGE TO SS WEARPLATES AND GASKETS, INCLUDE DEO 9124	

**RELEASED**  
07-06-28 *[Signature]*

QTY -041	Part Number	Description
X	D2590-041	SKIDTUBE ASSEMBLY
1	D2500-1-190	EXTRUSION
1	D2576-3	STEP
17	D2579	CROSS BOLT SPACER
10	D2594-1	PLUG
10	D2594-3	O-RING
1	D2597	204 WEB
1	D2855	AFT CAP
1	D3564-7	WEARSHOE
1	D3564-9	WEARSHOE
1	D3564-11	WEARSHOE
1	D3564-13	WEARSHOE
2	D3566-1	GASKET
1	D3566-7	GASKET
1	D3566-13	GASKET
44	ALS7-1032-130 or AKS7-1032-130 or AKS4-1032-130 or AELS-1032-130	INSERT
44	AN3C4A	BOLT
2	AN3-5A	BOLT
44	AN960C10L	WASHER
2	AN960JD10L	WASHER

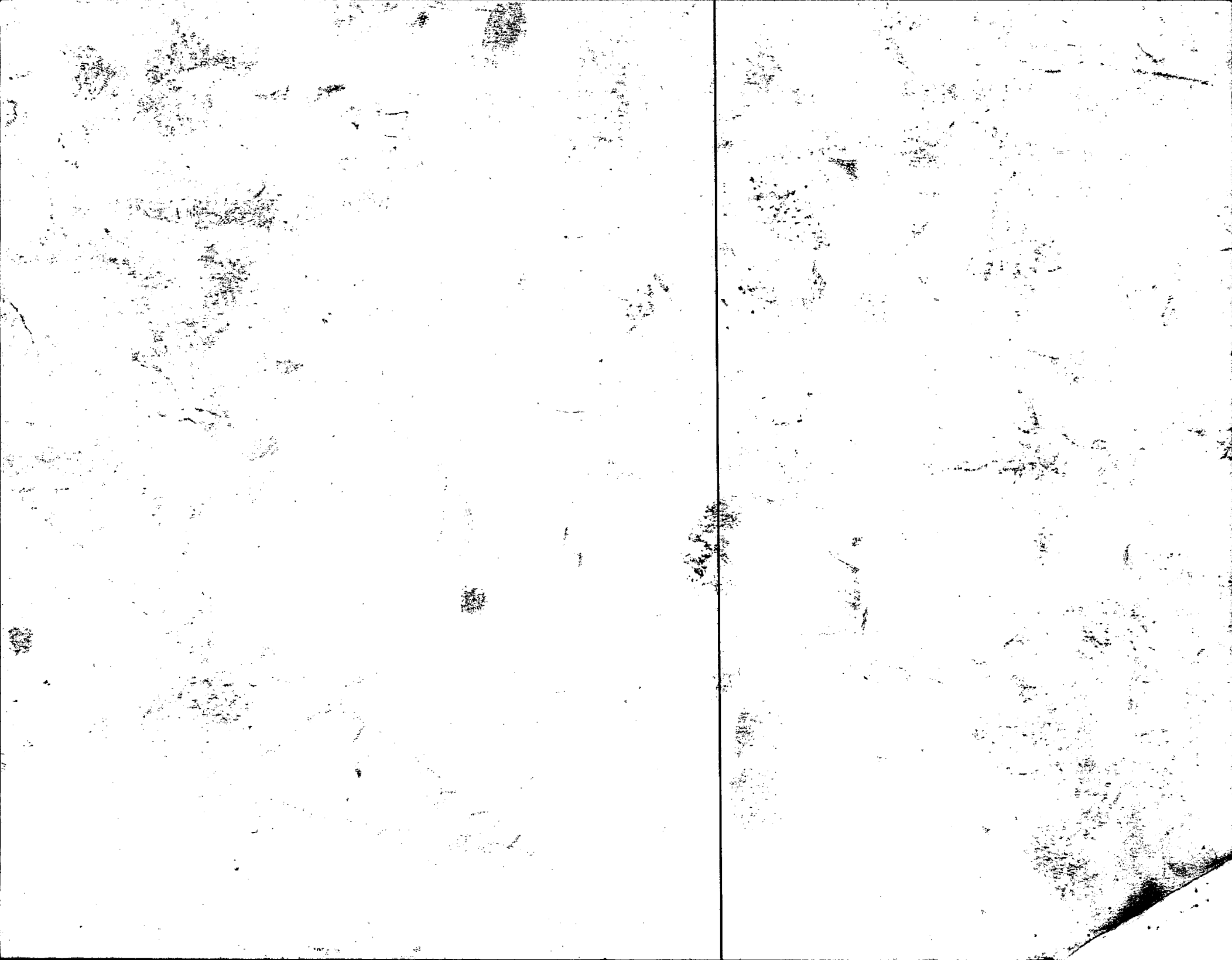
**GENERAL NOTES:**

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) INSERT D2597 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
- 4) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 5) USE DART DRILL TEMPLATE TD2577-204 TO LOCATE AND DRILL  $\varnothing 0.297$  HOLES FOR WEARSHOE INSERTS. INSTALL ALS7-1032-130 PER SECTION D-D (44 PLACES) AFTER FINISH. INSTALL AN3C4A BOLTS AND AN960C10L WASHERS WITH SIKAFLEX-241/-291.
- 6) WELDING TO BE DONE PER DART QSI 004.
- 7) FINISH:  
ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2596 WEB  
POWDER COAT ASSEMBLY GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4
- 8) INSERT D2594-1 PLUG C/W D2594-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (16 PLACES).

SHOP COPY  
RETURN TO  
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UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 37317A

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37.50  
DISTANCE TO AFT END  
OF D2597 WEB

3  
7

1.750 1.750

#0.508 (TYP.)  
(34 PLACES)

REFER TO DETAIL A

8.750 17.375 26.000 35.000 36.000 (REF)  
4 EQUAL SPACES  
9.00 PITCH

38.0 71.000 169.5  
(D2500-1)

Diagram illustrating the underside of the D2576 component, showing the locations for grinding flush and the location of the ridge on the underside of the D2576.

- GRIND FLUSH (4 PLACES)
- GRIND FLUSH
- D2576-3 STEP
- GRIND FLUSH
- LOCATION RIDGE ON UNDERSIDE OF D2576
- $\frac{1}{4}$

Figure 1 is a plan view diagram of a road layout. It shows a transition from a straight section to a curve. The diagram includes the following dimensions and labels:

- 1.4**: Offset from the centerline to the hole.
- 1.0**: Distance between the hole and the tangent point.
- 13.4**: Distance from the centerline to the hole.
- 25.4**: Offset from the centerline to the hole.
- 6.5**: Distance between the hole and the tangent point.
- 37.5**: Distance from the centerline to the hole.
- 11.5**: Offset from the centerline to the hole.
- 1.0**: Distance between the hole and the tangent point.
- 40.640**: Radius of the curve.
- 4**: Angle of the curve.

Technical drawing showing a bolt installation detail. The drawing includes the following labels and dimensions:

- DRILL PRIOR TO D2855 CAP INSTALLATION (2 PLACES)
- AN3-SA BOLT (1)
- AN960JDIOL WASHER (1) (2 PLACES)
- D2855 CAP
- SEAL WITH SIKAFLEX-241
- 0.40

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WITHOUT NOTICE  
WORK ORDER  
NO. 3737A

**DZ50-041 ASSEMBLY DETAIL**

WELD AS PER DETAIL B

BLACK ANTI-SKID TOP OF STEP TO 0.5 ABOVE BOTTOM EDGE

BLACK ANTI-SKID TO 0.5 ABOVE LOCATION RIDGE

8

0.5

1.5

1.5

1.5

1.5

P P P P P

D

D

REFER TO DETAIL C

D3566-1

D3566-7

D3566-1

D3566-13

D3564-11

D3564-7

D3564-9

D3564-13

AN3C4A "BOLT (1)



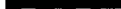


AN960C10L WASHER (1)

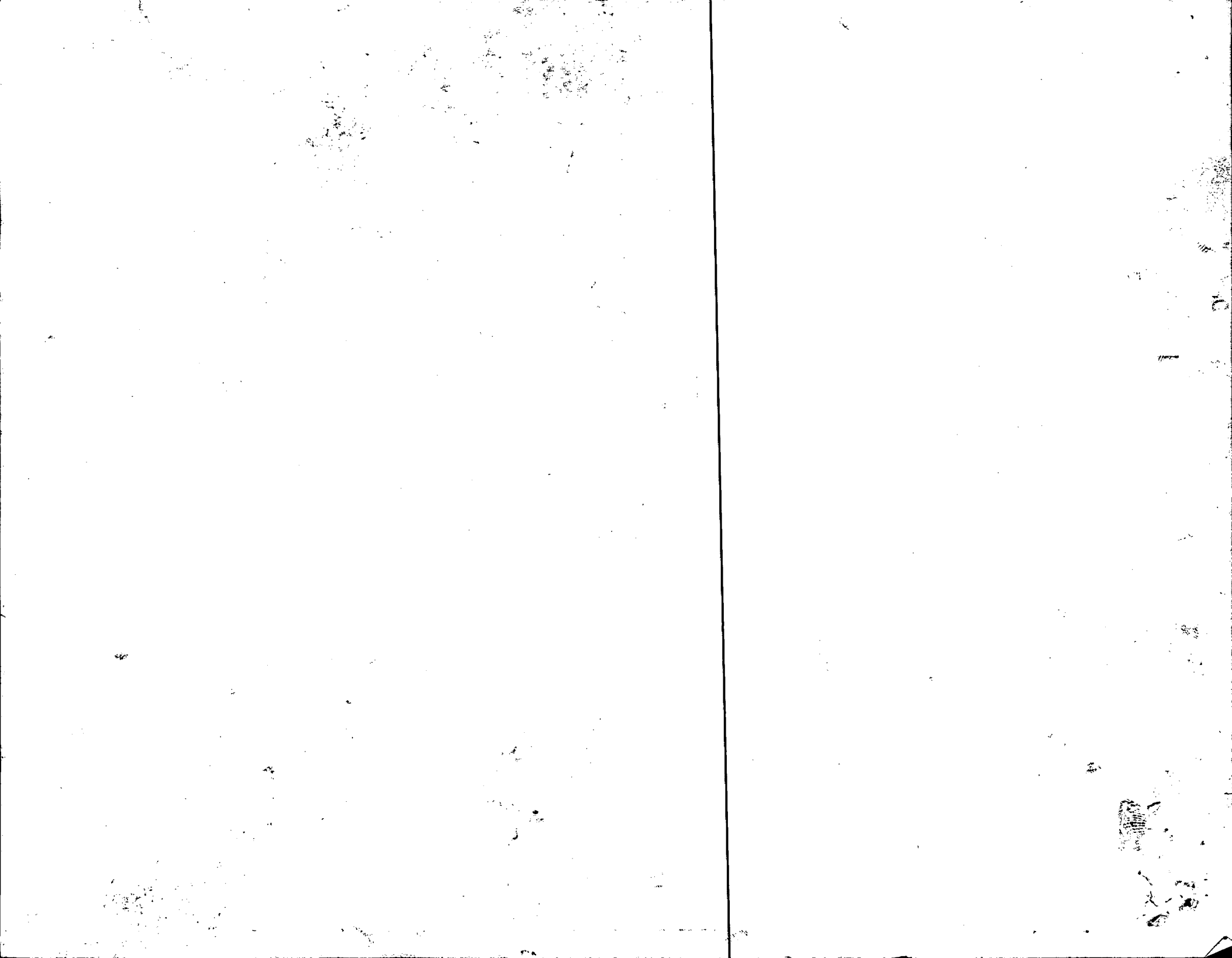
(44 PLACES)

D2579 SPACER  
 D2597 WEB (REF)  
 ALS7-1032-130 (REF)  
 (TYP 44 PLACES)

AFTER DRILLING AND BENDING ASSEMBLY  
 PERFORM THE FOLLOWING FOR #50.508 HOLES ONLY:

1. CHAMFER HOLE 0.050 X 45°
2. INSERT D2579 SPACER (17 PLACES)
3. WELD INTO PLACE AND GRIND FLUSH
4. C'BORE D2579 SPACER TO #0.437 X 1.00 DEEP

DESIGN 	DRAWN BY 	 <b>DART AEROSPACE LTD.</b> MISSISSAUGA, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO: D2590	REV. 0 SHEET 2 OF 2
DATE 07.04.05		TITLE 204 SKIDTUBE ASSEMBLY SCALE 1:24	



NO. 141

# AWS D17.1.2001 QUALIFICATION TEST RECORD

Name Bazley E.  
Joint Welding Procedure GTAW  
Part number and Job number D 305 64 01 / B367214

## TEST WELDS REQUIRED

BASE METAL Aluminium WELDING PROCESS TIG  
Penetration Complete ☐ Partial ☒ Single Weld ☒ Double Weld ☐  
Current AC ☒ DC ☐ Backing YES ☐ NO ☒

	Position	Vertical	Down <input type="checkbox"/>	Up <input type="checkbox"/>
Sheet Groove	1G <input type="checkbox"/>	2G <input type="checkbox"/>	3G <input type="checkbox"/>	4G <input type="checkbox"/>
Tube Groove	1G <input type="checkbox"/>	2G <input type="checkbox"/>	5G <input type="checkbox"/>	6G <input type="checkbox"/>
Sheet Fillet	1F <input type="checkbox"/>	2F <input type="checkbox"/>	3F <input type="checkbox"/>	4F <input type="checkbox"/>
Tube Fillet	1F <input type="checkbox"/>	2F <input type="checkbox"/>	4F <input type="checkbox"/>	5F <input type="checkbox"/>

Crossbolt Spacer Welded into Skidtube

## TEST RESULTS

Visual Pass ☒ Fail ☐  
Penetration Pass ☒ Fail ☐  
Crossbolt Spacer Pass ☒ Fail ☐

The above named individual is qualified in accordance with AWS D17.1.2001 to weld

Date of Test Coupon 02-03-01 Qualifier Del Duval